

Work Order ID 151962

Friday, October 14, 2016 1:56:10 PM

151962

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Item ID: D2435 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw
Start Date: 9/29/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS Date: OCT 17 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2435	Rev E1								

120 FLOW WATER JET 0.00

120

Waterjet

Memo

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

130 HAAS CNC VERTICAL MACHINING #1 0.05

130

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Deburr

140 QC2- Inspect parts off machine FAI/FAIB 0.00

140

QC

Memo

Quality Control

4 0 0 0 0 0 0 0 0 0
16/10/24
DAS
49
9-89
16/11/07
DAS
33
9-89
16/11/08

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150						4	0		DAS 45 9-89
QC	Memo	0.01							2016-11-09
Quality Control									
151	Identify as per dwg & Stock Location: <u>5446A</u>	0.00							
151						4			DAS 6 9-89
Packaging	Memo	0.01						NOV 08 2016	
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									16/11/10
QC	Memo	0.07							
Quality Control									

DAS
21
9-89

NOV 10 2016

Picklist Print

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Work Order ID: 151962

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Parent Item: D2435

D2435

Parent Item Name: Bearpaw

Start Date: 9/29/2016

Required Date: 10/14/2016

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	91.5000	3.2	12.8			

MUHMWB10

oc 16/10/24

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT

77.5

m135497

77.5

MAT018

14

m135013

14

13.5

DART AEROSPACE LTD		Work Order:	15P62
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.058 x 45°	/		vern	mm L-05
B	5.500	+/-0.030	5.501	/			
C	0.200	+/-0.030	0.196	/			
D	R0.250	+/-0.030	0.250	/		RG	
E	0.250	+/-0.010	0.244	/		micro	mm L-01
F	0.625	+/-0.030	0.618	/		vern	mm L-05
G	0.25 x 45°	+/-0.030	0.25 x 45°	/			
H	0.375	+/-0.010	0.380	/			
I	19.000	+/-0.030	19.00	/		tape	
J	0.950	+0.030/-0.010	0.952	/		vern	mm L-05
K	Ø0.260	+0.005/-0.000	0.260	/			
L	Ø0.930	+/-0.030	0.929	/			
M	0.30	+0.030/-0.000	0.310	/			
N	0.375	+/-0.030	0.380	/			
O	7.375	+/-0.030	7.380	/			
P	4.250	+/-0.010	4.250	/			
Q	2.000	+/-0.030	2.016	/			
R	9.000	+/-0.010	9.004	/		vern 12"	CNC-02
S	15.750	+/-0.030	15.750	/		tape	

DAS 33 9-89 16/11/08	Measured by: DAS 49 Date: 16/11/08	Audited by: DAS 45 Date: 2016-11-09	Prototype Approval: N/A Date:
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Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

DART



RELEASED
19.06.17 KE

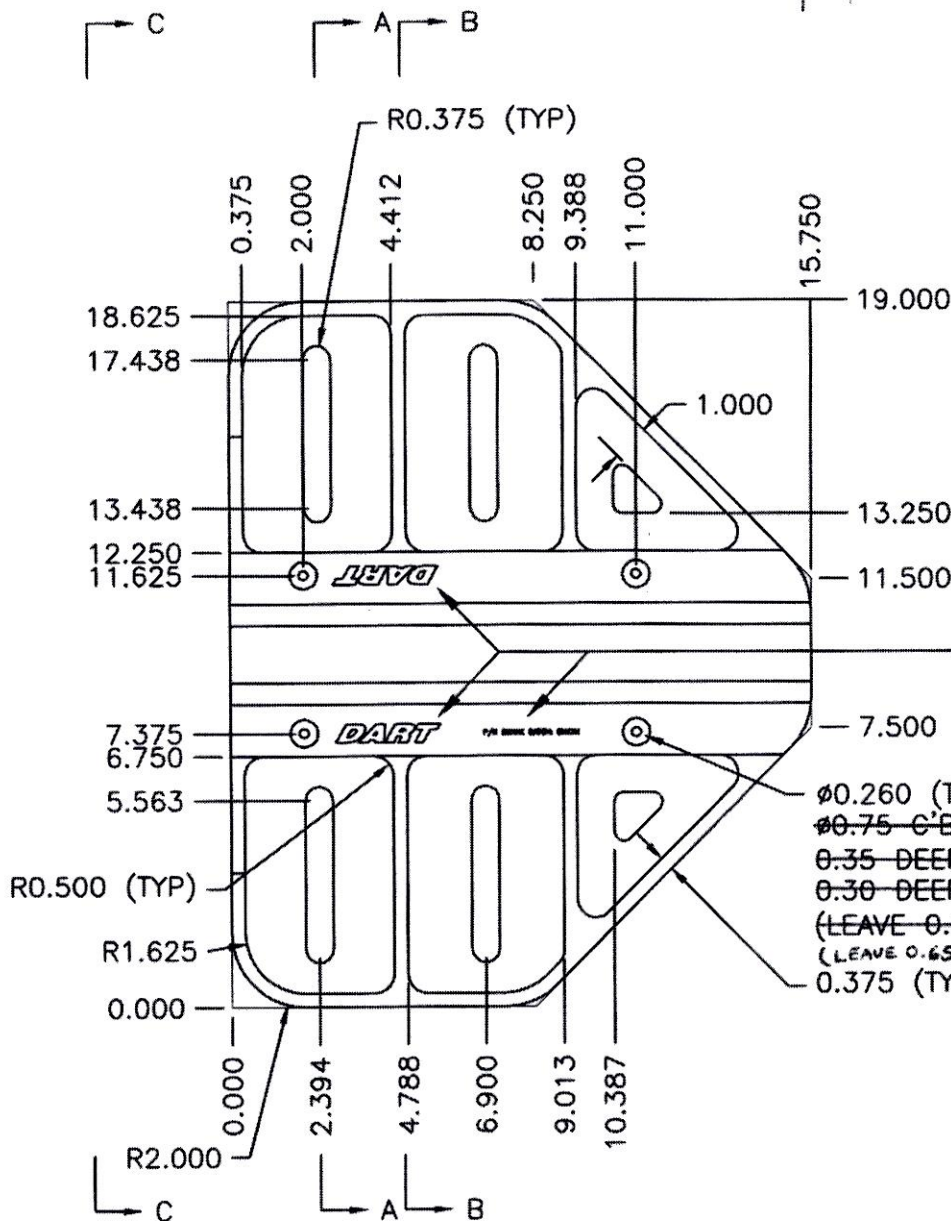
DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
98.05.19		D2435
DATE	TITLE	SHEET 1 OF 2
	BEARPAW	SCALE
		1:5

A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151962 MLC
1610-17

E1 02.12.17 $\phi 0.93$ WAS $\phi 0.75$ ~~FEA~~

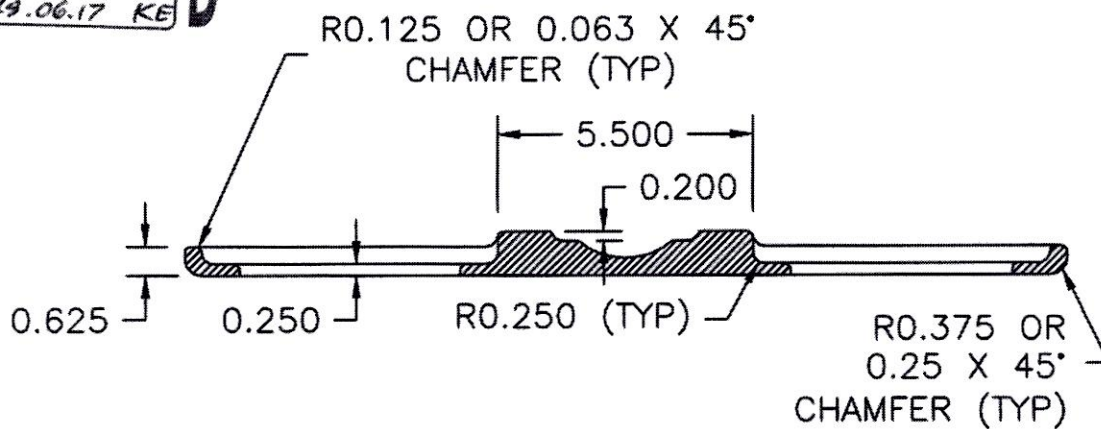


MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

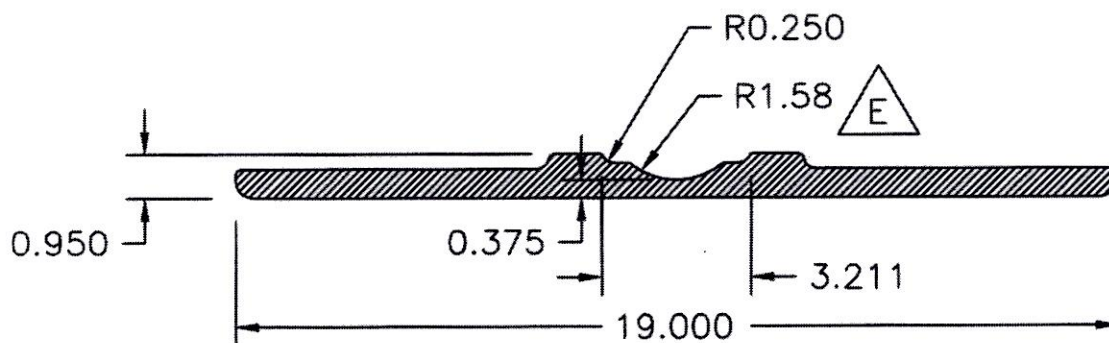


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DJB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

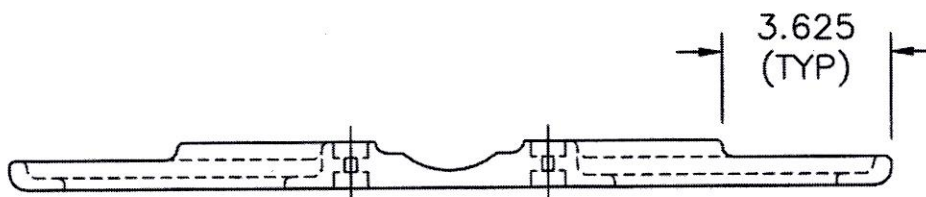
RELEASED
99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C